

# Work Order ID 54982

January 5, 2010 11:28:52 AM



Page 1

Item ID: D3246-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Bracket

Start Date: 05/01/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 18/01/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *RI*

Date: *10-1-05*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3246

Rev A1

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg Dsi9279 ☐ Dwg Rev: A1 ☐ Prog Rev: A1 ☐ 2-  
Deburr if necessary

*B 10-1-7*

*(8)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*FB 10-1-7*

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*⇒ 8/10/08*

*(XS)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 54982

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Item ID: D3246-041

Accept

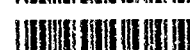


Setup Start



Revision ID:

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Item Name: Mounting Bracket

Start Date: 05/01/2010 Start Qty: 6.00



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Required Date: 18/01/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

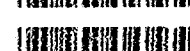
Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

Debur: Form as per Dwg D3246; C'sink as per Dwg D3246

SB 10/02/02  
EP 10/01/19

8

8

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

8 10/02/04

8

150



Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

BK 10-02-05

8

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Cust Item ID:

Required Date: 18/01/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00



7/11

10/02/05

(8)

QC

Memo

0.00

Quality Control

170

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Install Nut Plates as per Dwg D3246

8/10/02/08 (8)

180

QC5- Inspect part completeness to step on W/O

0.00



2/8 10/02/05

(+8)

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Required Date: 18/01/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

Identify as per dwg & Stock Location: 47

0.00



Packaging

Memo

0.00

Packaging

*Pickoff* (8)

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/11 *[Signature]*

ME 10-2-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

January 5, 2010 11:32:42 AM

Page 1

Work Order ID: 54982

Parent Item: D3246-041

Parent Item Name: Mounting Bracket

Comments:

Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Date Issued	Status
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MS21059L3

Purchased

No

110

Each

99.0000

24.0000



Nut Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

99

109962

11

111925

88

M2024T3S.050

Purchased

No

170

sf

172.3533

1.9560



2024-T3 .050 sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

172.3532842

111381

36.3165842

112291

88.0367

113189

48

MS20426AD3-3

Purchased

No

170

Each

6.251.000

48.0000



Rivet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6251

1563

0

19099

4776

7681

1475

9/5/10/02/08  
M113749 (324)

2.7  
B 10-1-7

18

113189

9/5/10/02/08

64

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

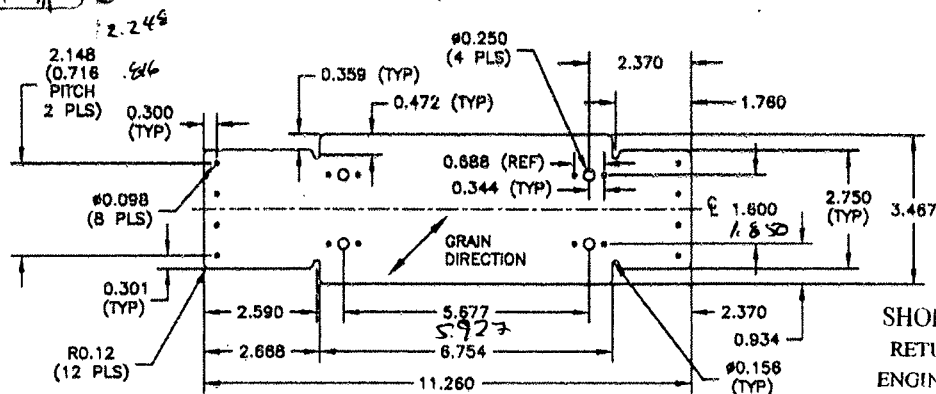
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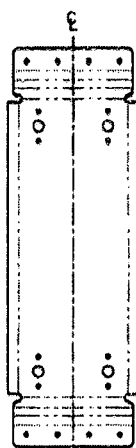
DESIGN 11	DRAWN BY 11	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 11	APPROVED 11	DRAWING NO. D3246	REV. A SHEET 1 OF 1
DATE 04.04.21		TITLE MOUNTING BRACKET	SCALE 1:4
A	04.04.21	NEW ISSUE	
AI	04.06.16	CHANGE RIVET, ADDED CLIP	

RELEASED  
04.05.07

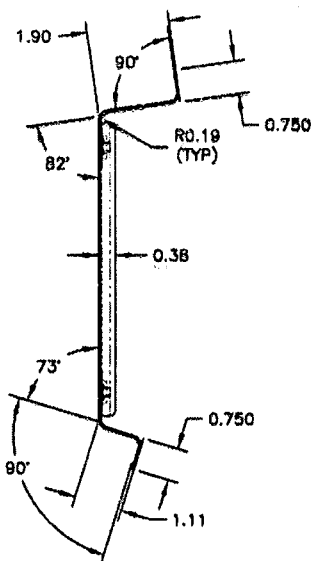


D3246-1 FLAT PATTERN

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO APPROVAL  
WITHOUT NOTICE  
WORK ORDER  
NO. 54982



D3246-1 BEND DETAIL



D3246-041 ASSEMBLY

MS21059-L3  
NUT PLATE (1)  
MS20470AD3-4 RIVET (2)  
(4 PLACES)  
INSTALL AFTER  
ALODINE  
BANK OF CLIP RIVET  
MS20470AD3-3 RIVET (2)

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (REF. DART SPEC. M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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